

Ship June 9

Work Order ID 133085

133085

Page 1

Item ID: D206-559-033

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: 206L Series/407 Bearpaw Wearplates

Stop *NS2*

Start Date: 5/22/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/26/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M C J

Date: MAY 26 2015

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-559	REV L

100

Document Control

0.00

DAS
27
9-89

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels per PPP D206-559-033 CHG 003

DAS
6
9-89

JUN 09 2015

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

DAS
27
9-89

JUN 08 2015

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

DAS
6
9-89

JUN 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 133085

Tuesday, May 26, 2015 12:43:38 PM

133085

Page 2

Item ID: D206-559-033

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206L Series/407 Bearpaw Wearplates

Start Date: 5/22/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00

120

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-559-033

Location: Ship

PPP Rev: _____

DAS
6
9-88

JUN 09 2015

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MCS

JUN 09 2015

MCS

JUN 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
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Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

Tuesday, May 26, 2015 12:43:34 PM

Page 1

Work Order ID: 133085

133085

Parent Item: D206-559-033

D206-559-033

Parent Item Name: 206L Series/407 Bearpaw Wearplates

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev B
10.10.04 per DSI9527 EC verified by:DD IPP REV:C 14.05.01
AS PER ECN14-544 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-17A		Purchased	No				Each	272.0000		12			
AN4-17A ** DAS 27 9-89													

Bolt

Location	Loc Qty	Loc Code
ST325A	200	
M131800	100	
<u>M132317</u>	100	
ST343	72	
M126105	48	
M127432	12	
M129909	6	
M131139	4	
M131377	2	

DAS
6
9-89

AN4-20A		Purchased	No				Each	215.0000		12			
AN4-20A ** DAS 27 9-89													

Bolt

Location	Loc Qty	Loc Code
GA	51	
116419	51	
ST325A	101	
m131803	1	
<u>m132342</u>	100	
ST343	63	
<u>128429</u>	36	
131677	1	
m132189	26	

DAS
6
9-89

JUN 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

Picklist Print

Tuesday, May 26, 2015 12:43:35 PM

Page 2

Work Order ID: 133085

133085

Parent Item: D206-559-033

D206-559-033

Parent Item Name: 206L Series/407 Bearpaw Wearplates

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 1.00

Required Qty: 1.00

D3859-041

Manufactured No

Each 1.0000

2

D3859-041

Wearplate
DAS
6
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST613

1

131346

1

Each

5,739.000

12

**

DAS
27
9-89

MS21042L4

Purchased No

MS21042L4

Locknut

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

26

m124231

26

GA

216

m127813

216

ST260a

4062

m130799

56

m131803

6

m132262

1000

m132382

3000

ST305

1435

m128300

8

m130388

7

m130922

97

m131618

12

m132123

1311

12

JUN 08 2015
DAS
26
9-89

DQA: _____ Date: _____



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Picklist Print

Tuesday, May 26, 2015 12:43:35 PM

Page 3

Work Order ID: 133085

133085

Parent Item: D206-559-033

D206-559-033

Parent Item Name: 206L Series/407 Bearpaw Wearplates

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

5,690.000

12

NAS1149D0463.I

WASHER

**

JUN 08 2015

DAS 26 8:00

DAS 6 3:00

Location

Loc Qty

Loc Code

GA	41	
M129390	41	
ST260a	2000	
M132317	2000	
ST269	3649	
M129682	86	
M130799	371	
M132035	3192	

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																												
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